

5/24

DART AEROSPACE LTD	Work Order:	23330
Description: Lug	Part Number:	D2731-5
Drawing: D2731 Rev. B	Qty:	51 52

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	JA	05.05.20	50
2	METAL	Cut D2423 extrusion to .82"	SD	03.05.26	50
3	HAAS PG	Machine as per folio D2731-5 Check for crack while loading into the machine	LI	05.05.25	50
4	QC PG	Inspect Level 2 Receive & Inspect for transit damage	DL	05/06/27	51
5	QC	Inspect Level 5	2	05.06.03	51
6	METAL	Tumble Deburr any rough edges after tumbling if applicable	N/A	2	
7	METAL	Acid etch and alodine as per QSI 005 4.1	FF	05.08.04	51
8	QC	Inspect Level 7	2	05.10.27	51
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) per Dart QSI 005 4.3	ML	05.10.27	51
10	QC	Inspect Level 3	CA	05/10/27	51
11	STORES	Identify and stock	LU	05/10/27	51
12	EXPEDITING	Close W/O Cost / Part: 18.80 545 05/10/28 51	19	05/10/28	51

03.05.27

Rev	Date	Change	Revised By	Approved
A	98.10.20	New Issue	KB	
B	99.03.15	Re-format, Added Acid Etch (ECN 170)	DM	
C	99.08.03	Drawing to Rev B, ECN 213	DM	
D	00.05.19	Added inspect level 8, removed P/O for powder coating	EC	

RELEASED

EC 00.05.24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

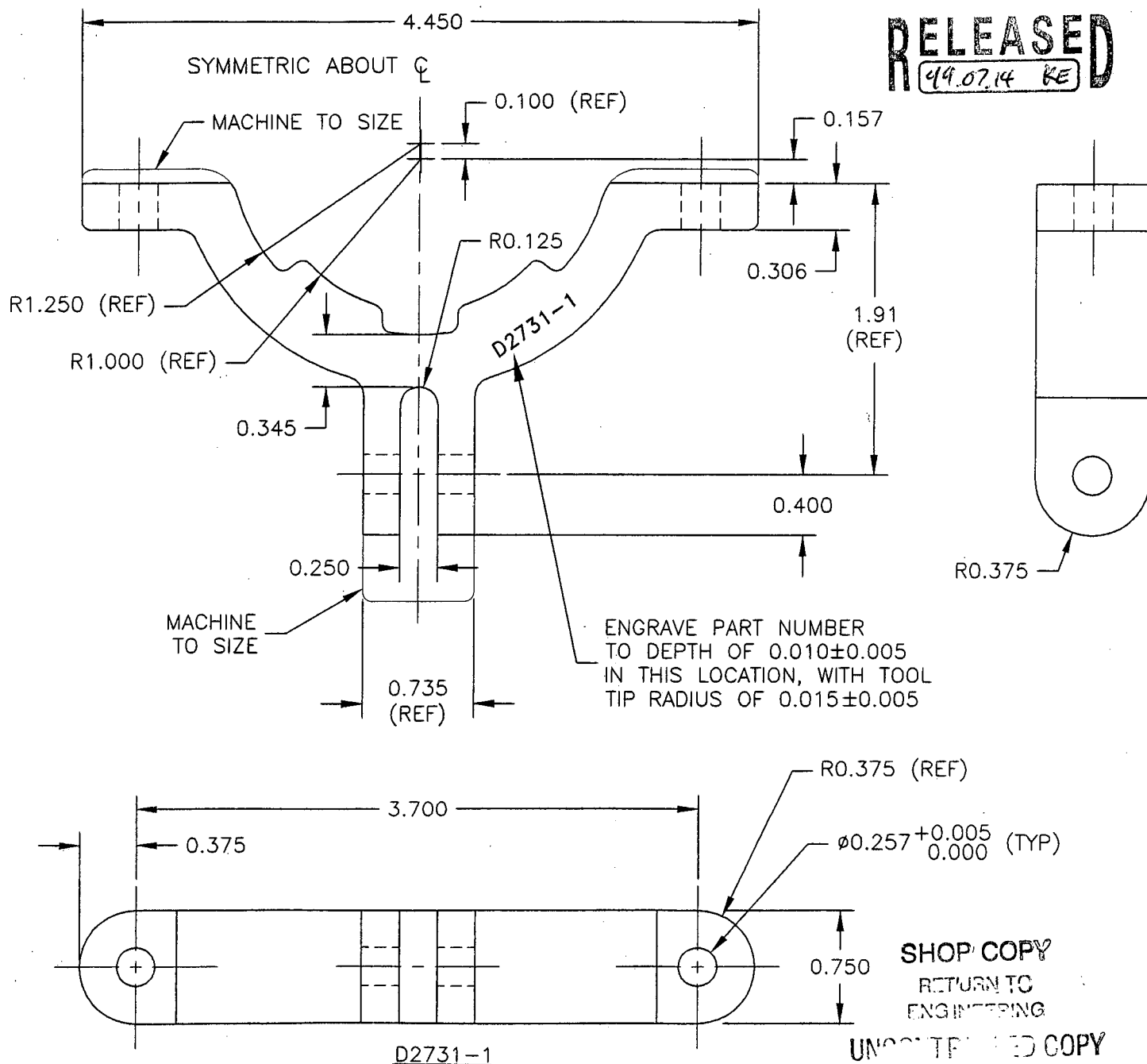
NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: *PS* Date: 05/10/28

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



RELEASED
49.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NOTICE

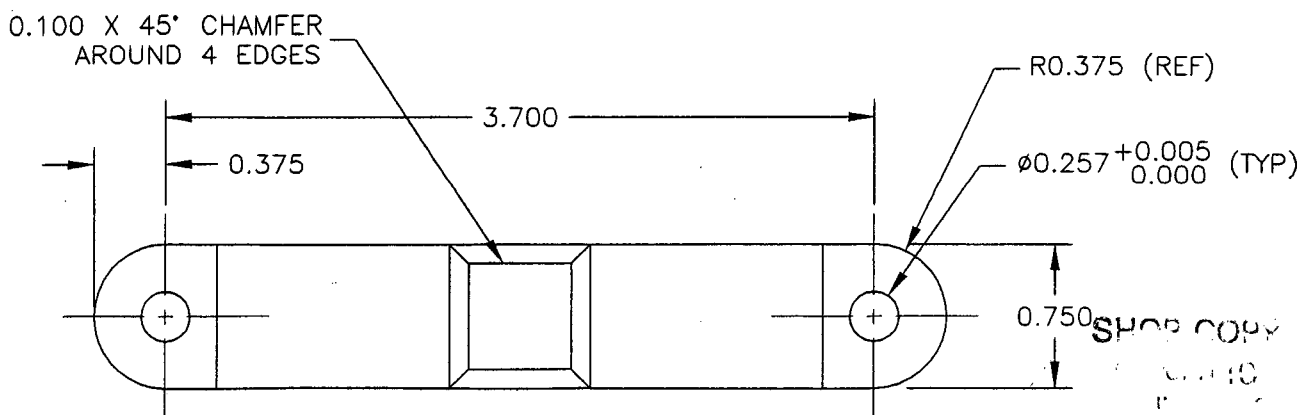
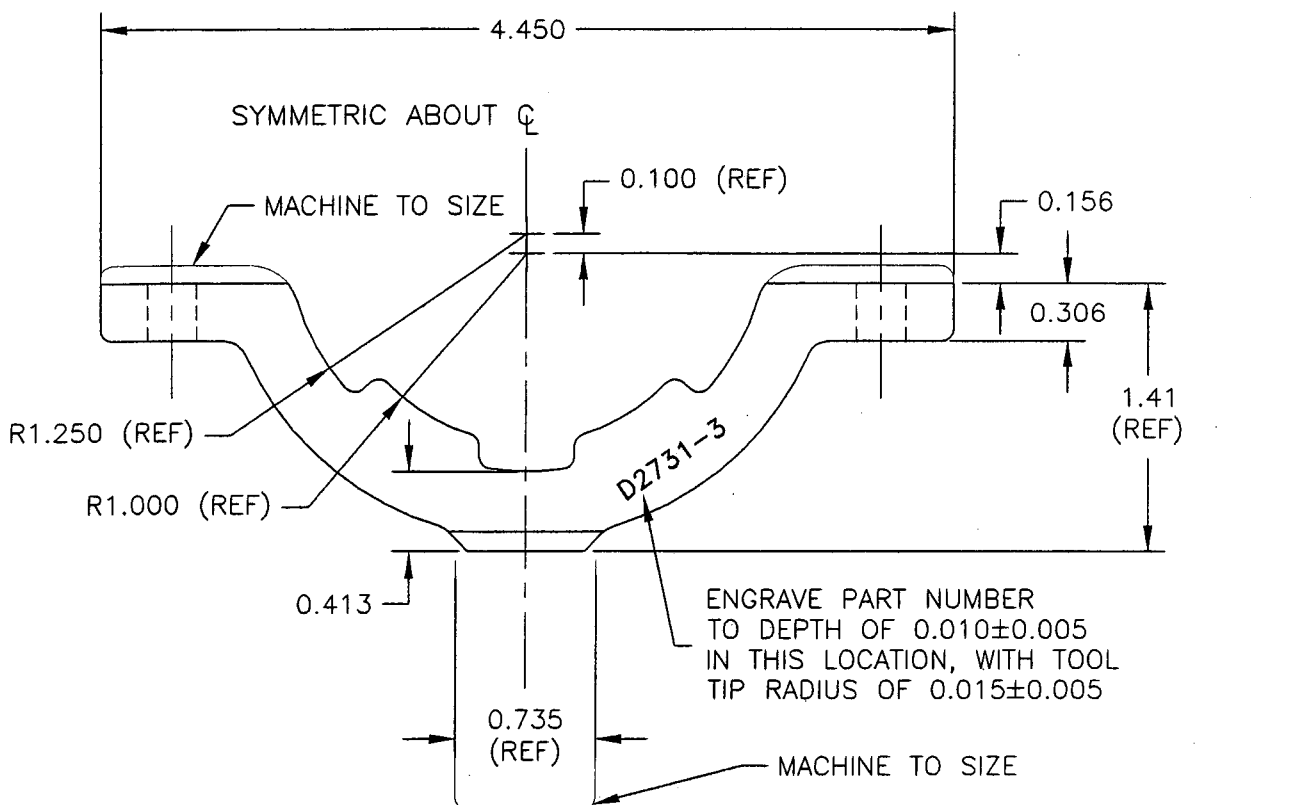
WORK ORDER

NO. 23330



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

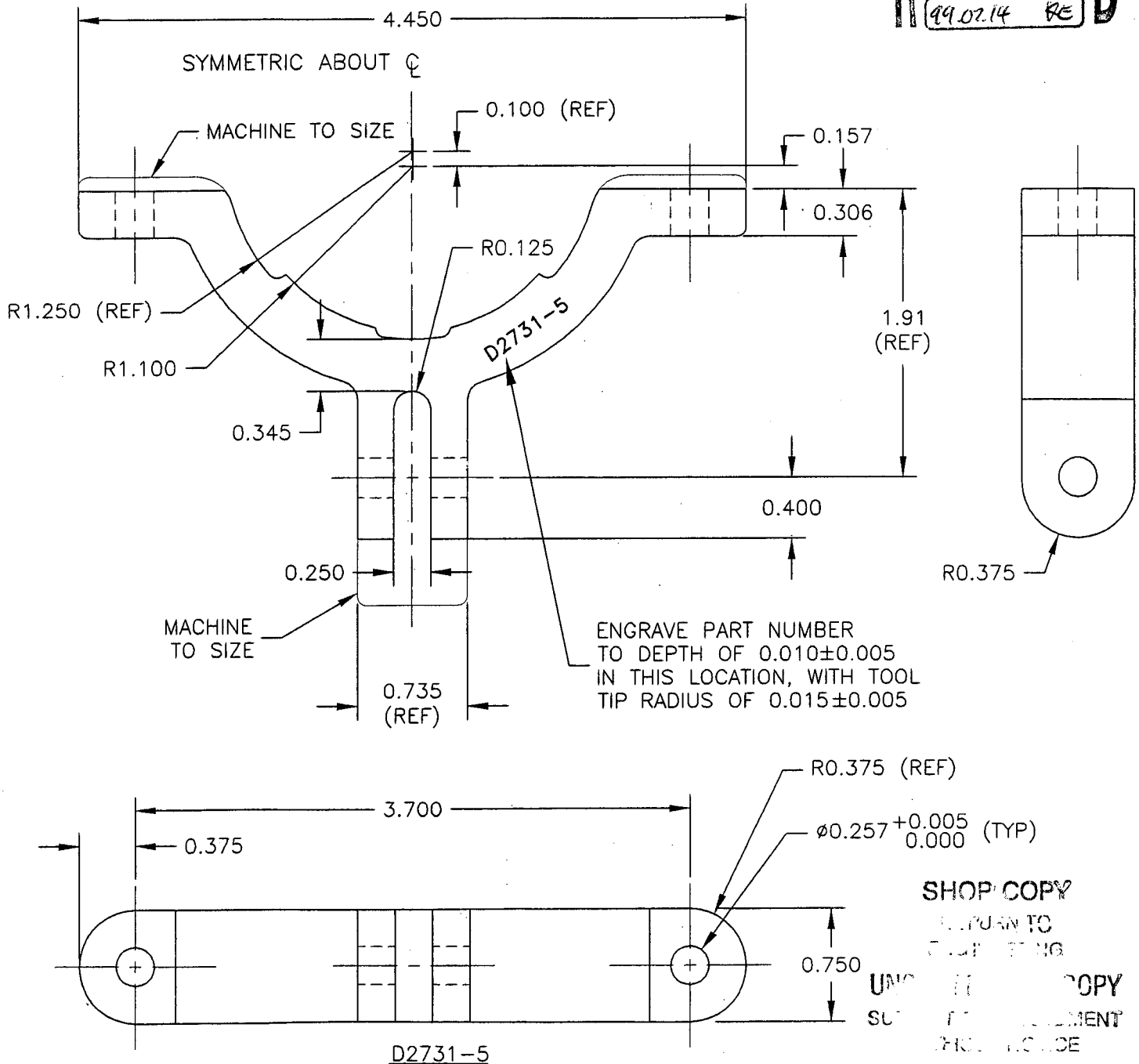
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WORK ORDER
NO. 23330



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*



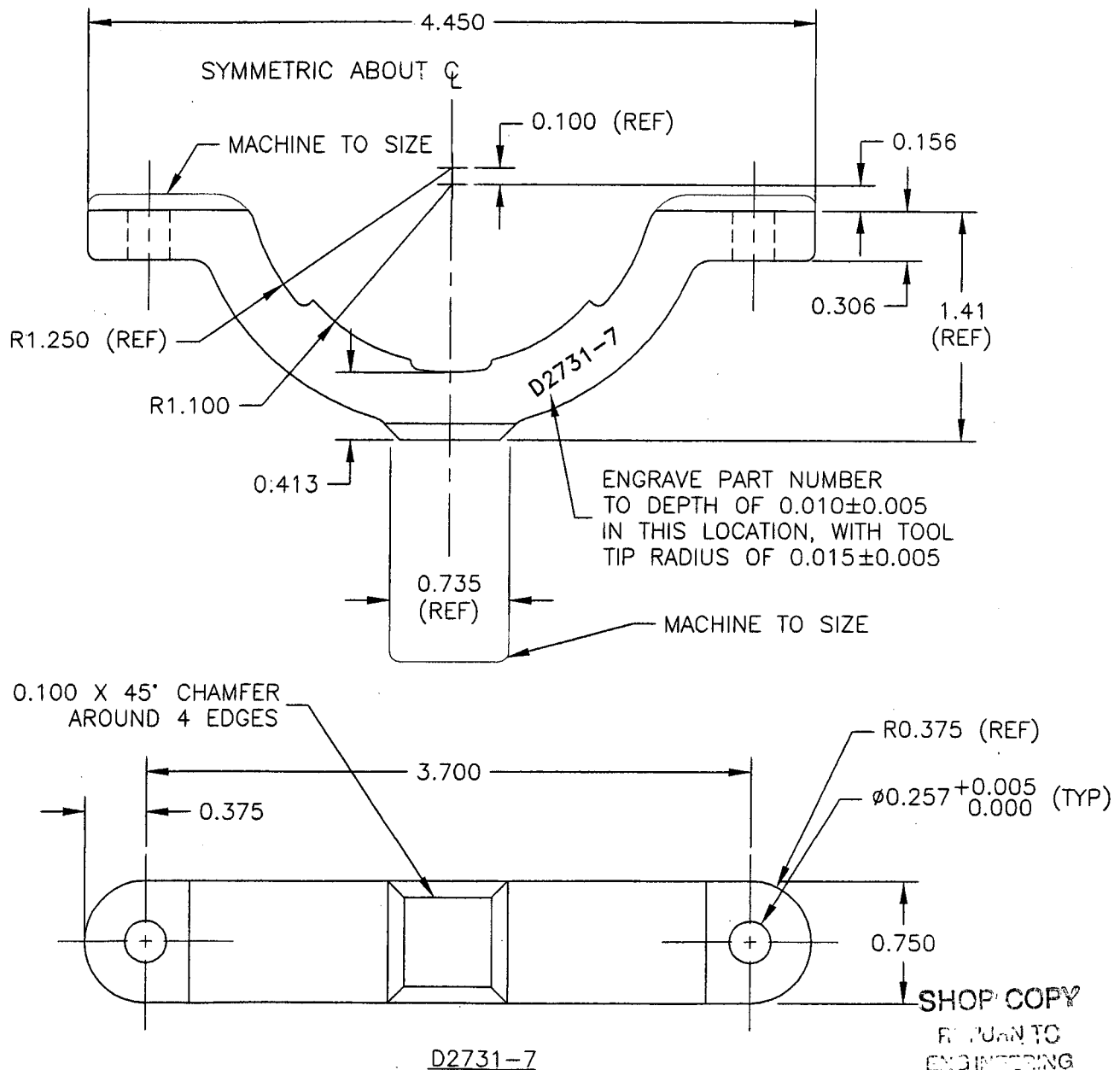
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 23330



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
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WORK ORDER
NO. 23330

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023330
Project Name : D2731-5
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2731-5
Description : Mounting Lug
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 05-16-05
Est Finish Date : 06-16-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00